

May 20 12:52

Work Order ID 69684

Monday, May 16, 2011 10:47:52 AM



Item ID: D4155-1

Accept



Setup Start



Revision ID:

Item Name: Bar

5.00

Stop



Start Date: 5/16/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 5/18/2011 Req'd Qty: 6.00

Customer:

Reference:

Approvals:

Process Plan: *W*

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4155	B								

100

0.00



Cold Saw

Memo

0.00

Hyd Mech

Cut blanks at 91.75"

110

0.00



HAAS I

HAAS CNC vertical machine #1

Memo

1-Mill as per folio FB048 & dwg D4155,

FOLIO REV: \_\_\_\_\_

DWG REV: \_\_\_\_\_

2-Deburr as required

*11/05/17* *(5)*

*11/05/17* *(5)*

*Manual mill*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Customer:

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Date:

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Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

120

QC2- Inspect parts off machine FAI/FAIB

0.00

11/05/18

5



QC

Memo

0.00

Quality Control

130

QC8- Inspect parts - second check

0.00

11/05/18

5



QC

Memo

0.00

Quality Control

140

0.00



Small Fab

Memo

0.00

Small Fab

Grind off chamfer on fwd end of bar as per dwg

11/05/18

5

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Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

150



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

8/11/19

(45)

160



Packaging

Packaging

Identify as per dwg & Stock Location: W/A

0.00

Memo

0.00

EL 11-579. (45)

170



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

- 11/5/2019  
ME 11-05-19

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# Picklist Print

Monday, May 16, 2011 10:47:49 AM

Page 1

Work Order ID: 69684



Parent Item: D4155-1

Parent Item Name: Bar

Start Date: 5/16/2011

Required Date: 5/18/2011

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev:A 10.08.03 new issue DD verf:EC  
11.04.14 as per dwg revB DD verf:EC

IPP Rev:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304B0.250x0.500		Purchased		No		100	f	230.2000	7.6333	48.21032			

304 BAR .250 x .500

Location

Loc Qty

Loc Code

MAT006

78

116148

78

MAT050

152.2

117176

152.2

40.81 ST 11/05/17

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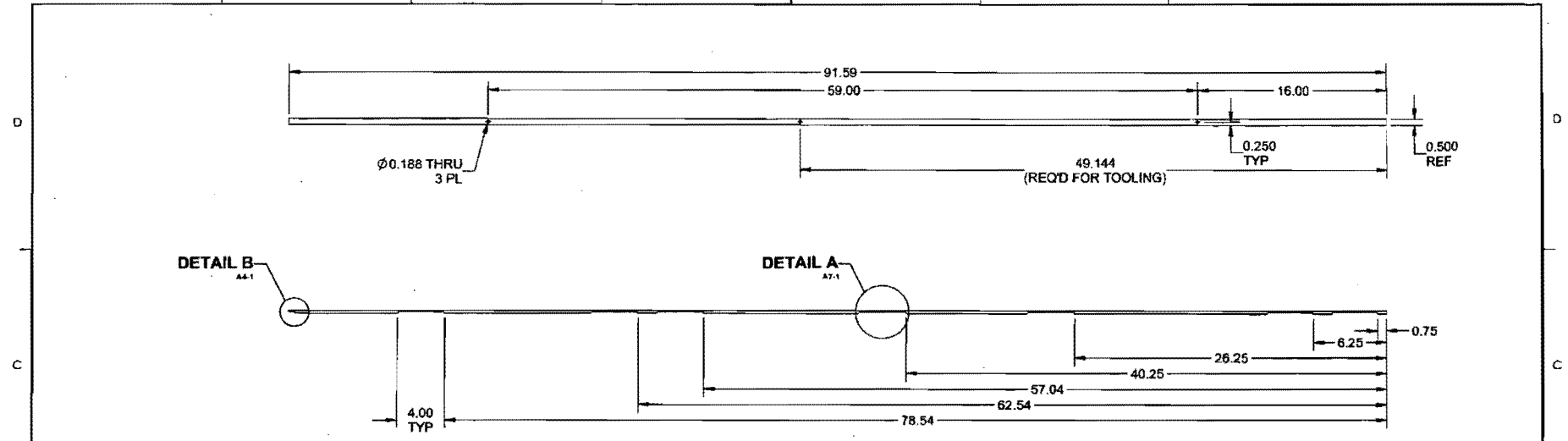
**NOTE:** Date & initial all entries



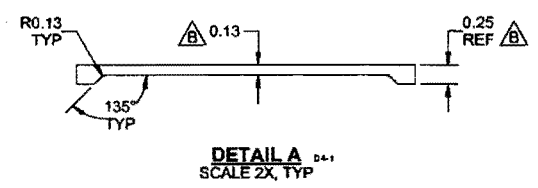




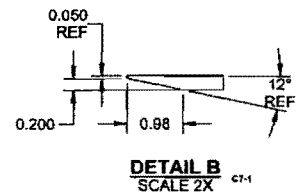
8 7 6 5 4 3 2 1



**D4155-1 BAR**



**DETAIL A D4-1  
SCALE 2X, TYP**



**DETAIL B A7-1  
SCALE 2X CT-1**

**RELEASED**  
2011-04-13

- NOTES:**
- 1) MATERIAL : AISI 304/316 STAINLESS STEEL BAR, 0.25 THICK X 0.50 WIDE PER ASTM A276 OR ASTM A240  
REF. DART SPEC. M304B0.250X00.500
  - 2) FINISH : NONE
  - 3) TOLERANCES : PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS : INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES : 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION : NONE
  - 7) WEIGHT : 2.82 lbs

*WLB 69/6/84*

DESIGN	CHANGED MANUFACTURING PROCESS; MATERIAL WAS 0.50 THICK (A6-1); 0.25 REF WAS 0.20 (B6-1); 0.13 WAS 0.08 (B7-1)	MB	11.04.05
DRAWN	NEW ISSUE	SC	10.07.22
CHECKED	DESCRIPTION	BY	DATE
MFG. APPR.	<b>DART AEROSPACE USA, INC.</b>		
APPROVED	PORT HADLOCK, WA		
DE APPR.	DRAWING NO. <b>D4155</b>	REV. B	SHEET 1 OF 1
DATE	TITLE <b>BAR</b>	SCALE	NTS
11.04.05	COPYRIGHT © 2010 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR FOR ANY OTHER PERSON OR ENTITY WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.		

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